

Work Order ID 92596

92596

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November-01-12 1:12:03 PM

Item ID: D2739

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 3501 Beam

Start Date: 01/11/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-11-01

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

100

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

- 1-Cut D2600-5 to length as per Dwg D2739.
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

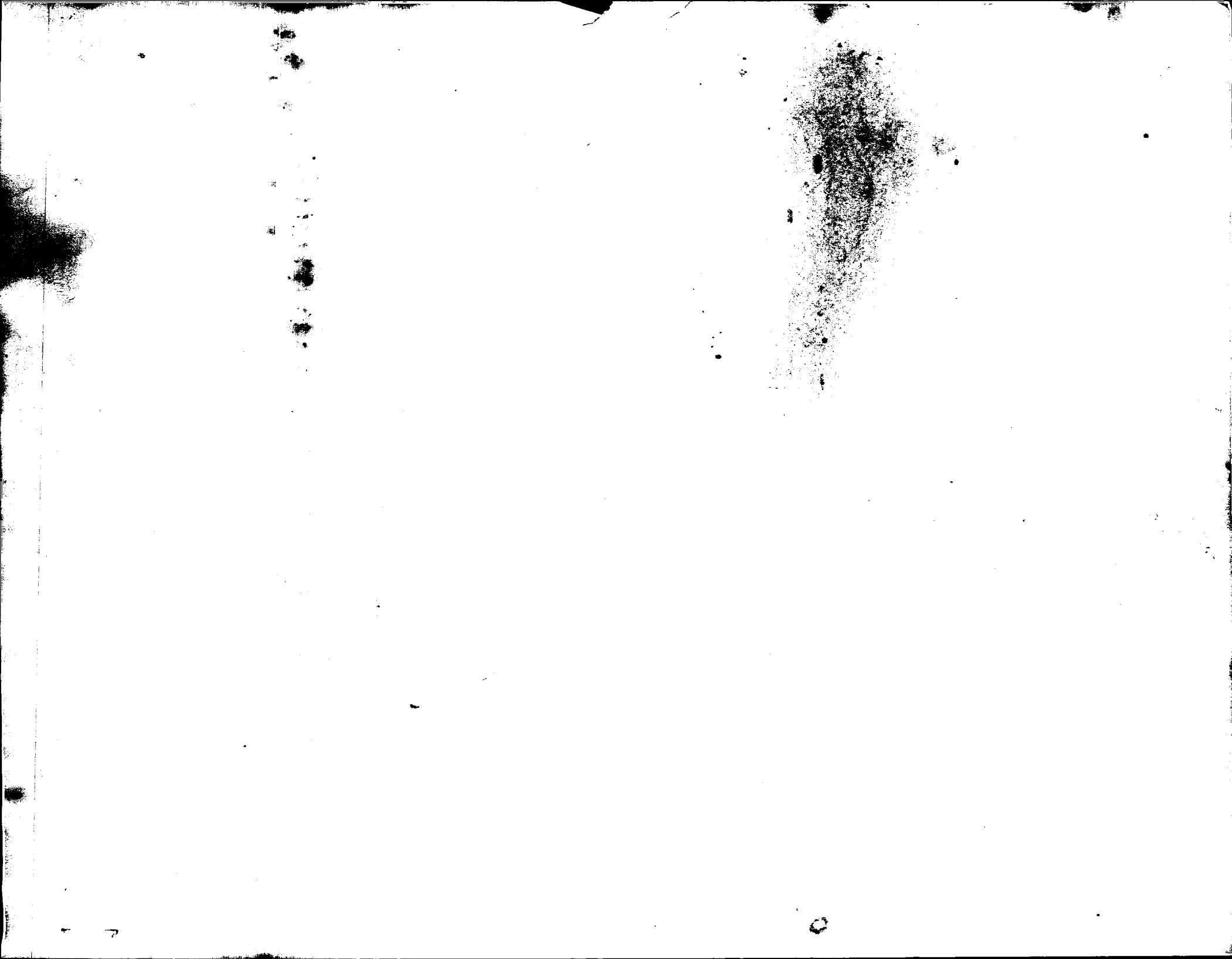
Memo

0.00

Hand Finishing

Dec 12/11/14

4 RLB 12/12



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92596

Page 2

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 01/11/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00


130

QC

Memo

0.00

Quality Control

4 0 12-11-14 

140

Identify as per dwg & Stock Location: **LG**

0.00

140

Packaging

Memo

0.00

Packaging

4 0 12-11-14

150

QC21- Final Inspection - Work Order Release

0.00

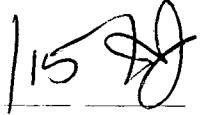
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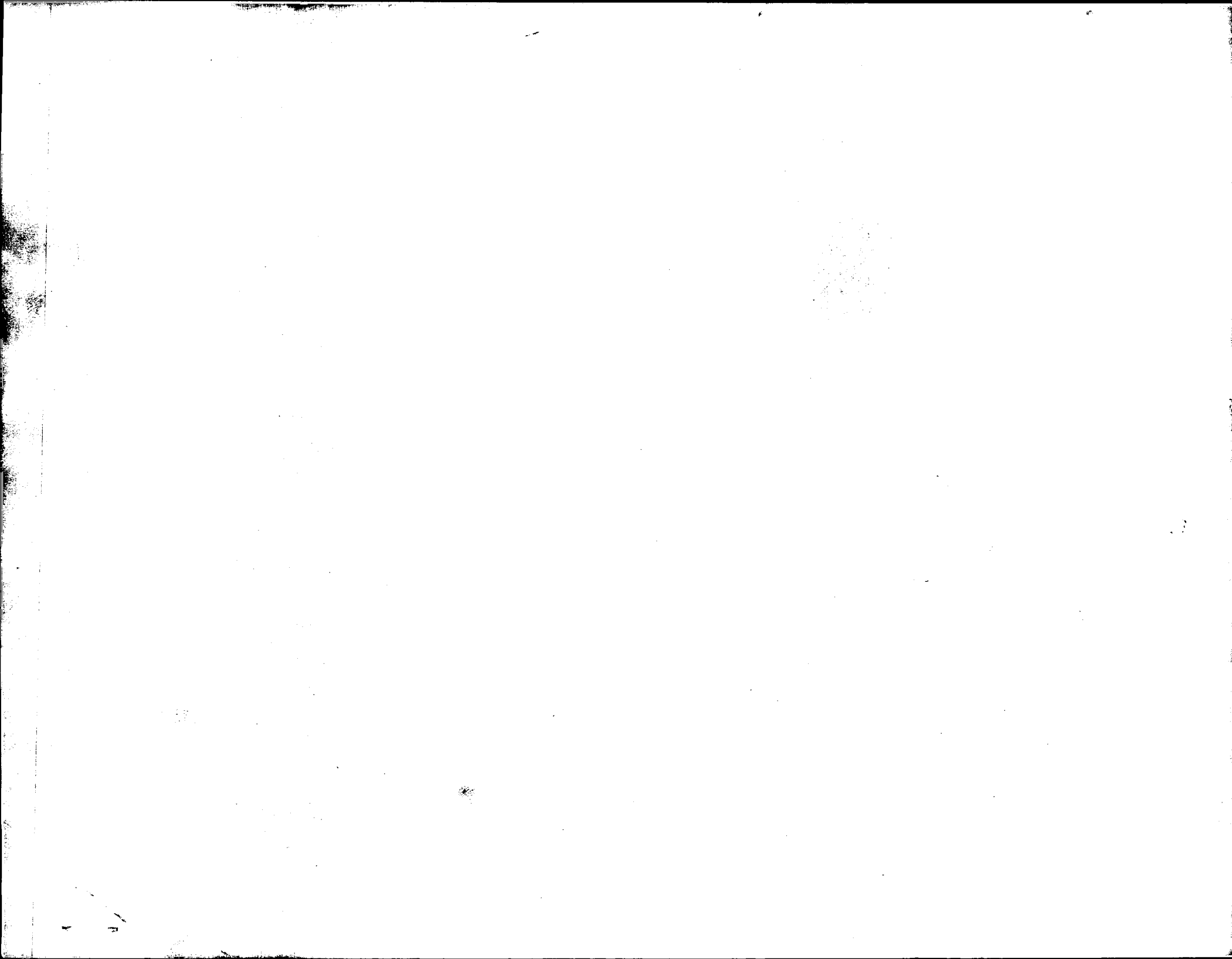
QC

Memo

0.00

Quality Control

12/11/15 
MP
12-11-14



Picklist Print

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Page 1

Work Order ID: 92596

92596

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 01/11/2012

Required Date: 15/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-080

Manufactured

No

Each

165.0000

4

D2600-5-080

**

Dec 12 / 11 / 12

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

LG

165

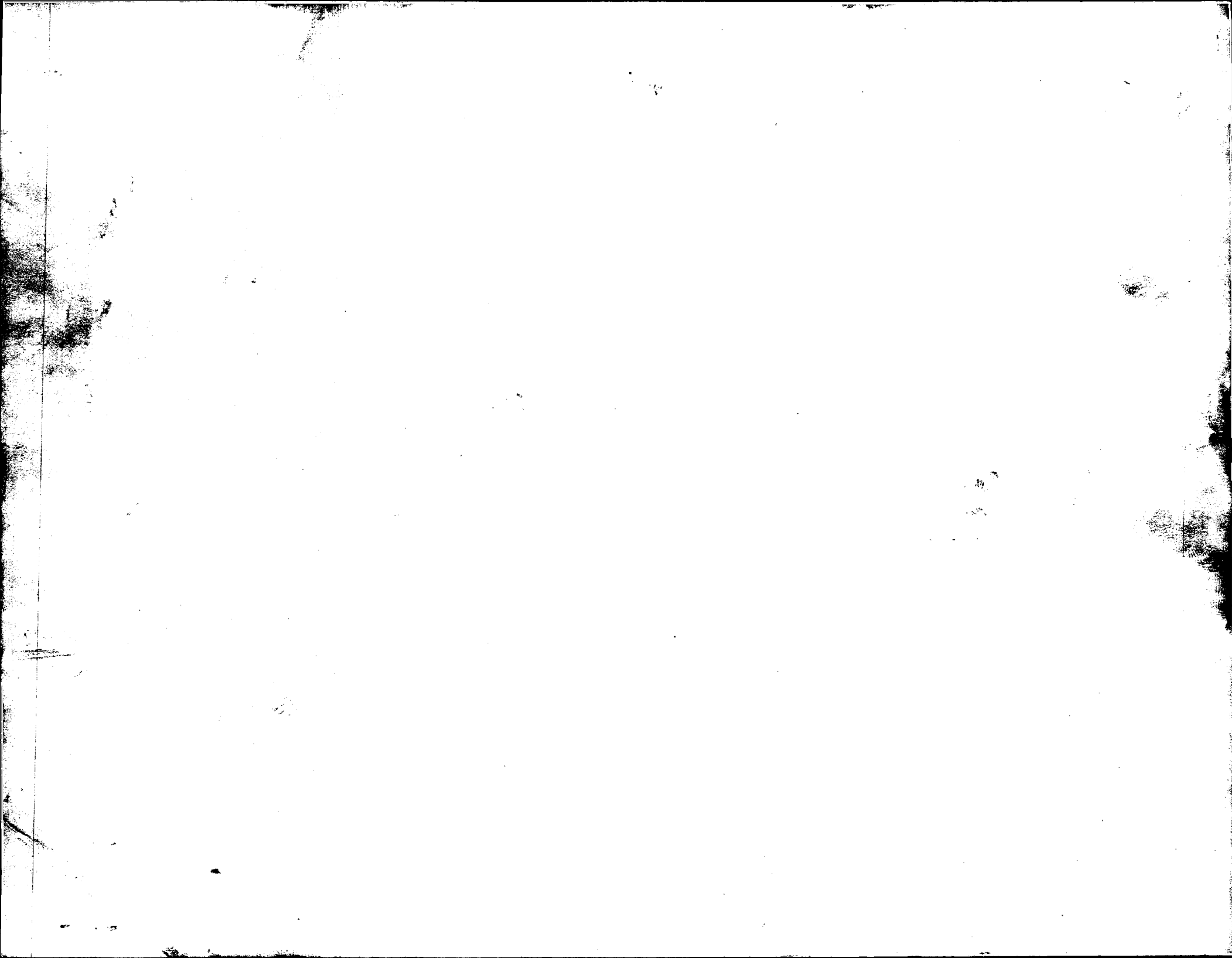
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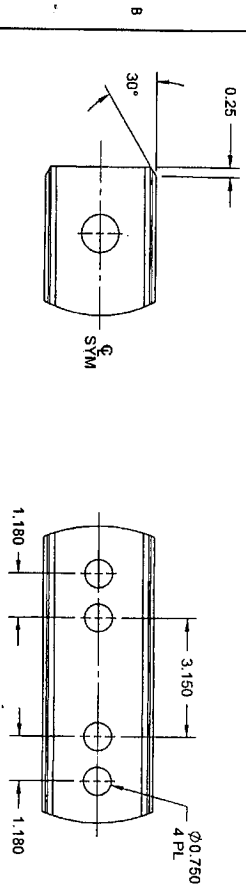
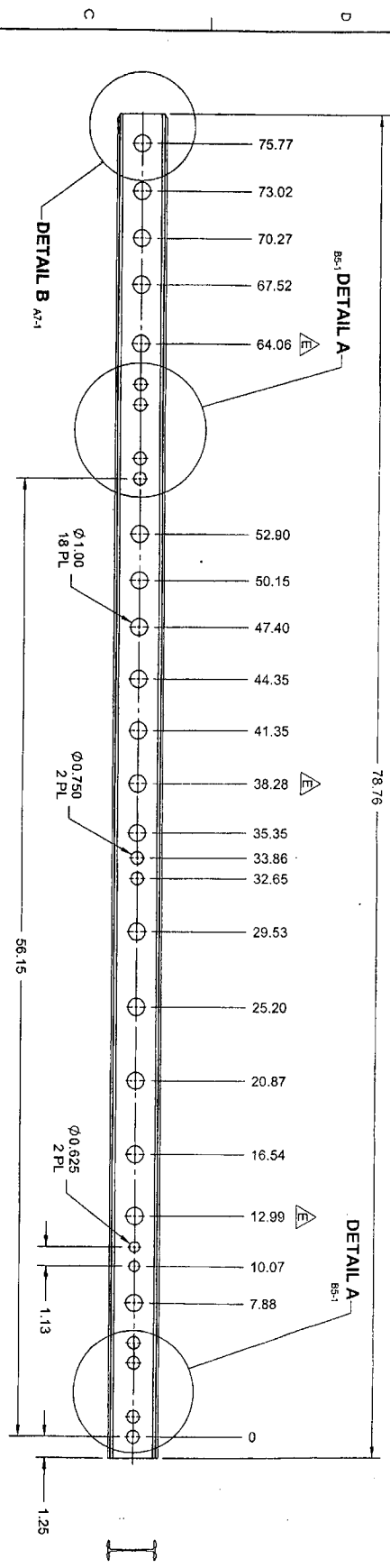
1

90683

164

4





DETAIL B
C7-1
SCALE 3X

DETAIL A
D7-1, D2-1
SCALE 3X

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART PIN "D2739" AND BIN PER DART OSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

SHEET
 RETURN TO
 UNCONTROLLED
 SUBMIT TO AMEN
 WORK ORDER
 NO. 92596 M15
 12-11-01

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DS	98.04.16
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCROSSER	CP	98.11.18
C	ADD BEVEL TO FWD END; ADD DETAIL B	PH	06.01.05
D	ADD BEVEL TO FWD END; ADD DETAIL B	DB	07.05.29
E	ADD MOVE HOLES FOR D2154 WEAR PLATE; 38.28 WAS 38.35 (DS-1); 64.06 WAS 64.17 (DS-1); ADD HOLE (DS-1)	CP	10.10.08

DESIGN	DS	DART AEROSPACE USA, INC.
DRAWN	CP	PORT HADLOCK, WA
CHECKED	DS	
MFG. APPR.	DS	
APPROVED	DS	
DE APPR.	DS	
DATE	10.10.08	

TITLE	D2739	REV. E
WEB		SHEET 1 OF 1
SCALE		
NTS		

RELEASED
 2010-11-01

